



Dart Aerospace Ltd.
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D3564-9

Job Sheet 199163



Part No: D3564-9

Job Qty: 20 pcs

Part Name: Wearplate Fwd



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/13/19

Job Tracking No:

Due Date: 8/27/19

Created By: Jennifer Renwick

Type: SOLD

Description:

Note: DWG REV E IPP Rev:A New Issue 07-03-08 ec IPP Rev:B As per Rev C 07-07-09 JLM IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	20 pcs		8/27/19	0.17	3.86	Waterjet - Flow		08/19/08/26
120	QC 8	20 pcs		8/27/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
130	Small Fab - Brake NC - B4B	20 pcs		8/27/19	0.25	1.06	Small Fab - Brake - 1 - B4B		
							Small Fab - Brake - 2 -		



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Container No: S208809



Part: D3564-9

Job No: 199163

Serial No/Batch: S208809

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 10/23/19

DAS

40

AUG 27 2019 9-89

DAS 30 0-89

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				B4B	
				Small Fab - Brake - 3 - B4B	SEP 10 2019
140 QC 5	20 pcs	8/27/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
150 Automated Welding - B4B	20 pcs	8/27/19	0.00 8.00	Automated Welding - 1 - B4B	
160 QC 10	20 pcs	8/27/19	0.00 0.00	QC 10 - 10	
				QC 10 - 18	
				QC 10 - 24	
				QC 10 - 43	
				QC 10 - 50	
				QC 10 - 58	
				QC 10 - 9	
170 QC 5	20 pcs	8/27/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
180 Spray Paint - 2 - B4B	20 pcs	8/27/19	0.00 6.67	Spray Paint - 1 - B4B	
				Spray Paint - 2 - B4B	
				Spray Paint - 3 - B4B	
				Spray Paint - 4 - B4B	
190 QC 5	20 pcs	8/27/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	

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				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	DAS
				QC 5 - 68	81
				QC 5 - 9	9-89
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	DAS
				QC 5 - 61	9-89
				QC 5 - 81	
200	Packaging 3-1 - Stock - B4B	20 pcs	8/27/19	0.00 0.00	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	✓
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
210	QC 21 - SA	20 pcs	8/27/19	0.00 0.00	
				QC 21 - SA - 21	✓
				QC 21 - SA - 70	
				QC 21 - SA - 53	
				Broussard	
					FP002
					DAS
					21
					9-89
					OCT 28 2019
Part Op 100 - 1-Cut as per DWG. DWG. Rev: <u>E</u> PROG. Rev: <u>E</u> 2-Debur if necessary Descriptions: 120 - (QC8- Inspect parts - second check) 130 - (Form as per dwg) 140 - (QC5- Inspect part completeness to step on W/O) 150 - (Automated welding)					

160 - (QC10- Inspect visual per QSI004- ground welds)
 170 - (QC5- Inspect part completeness to step on W/O)
 180 - TEXTURE COAT BATCH: 5207452
 190 - (QC5- Inspect part completeness to step on W/O)
 200 - (Identify as per dwg & Stock Location: _____)
 210 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	28.2000 sf (1.41 ea)	100-Waterjet - Flow - 1	5200442

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S16GA	28	284	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wearshoe	3.227inches $\pm$ 0.010	3.237 3.217		
2	Wearshoe	2.432inches $\pm$ 0.010	2.442 2.422		
3	Wearshoe	2.500inches $\pm$ 0.030	2.530 2.470		
4	Wearshoe	6.000inches $\pm$ 0.010	6.010 5.990		
5	Wearshoe	12.104inches $\pm$ 0.010	12.114 12.094		
6	Wearshoe	18.000inches $\pm$ 0.010	18.010 17.990		
7	Wearshoe	18.000inches $\pm$ 0.010	18.010 17.990		
8	Wearshoe	18.000inches $\pm$ 0.030	18.030 17.970		
9	Wearshoe	9.000inches $\pm$ 0.030	9.030 8.970		
10	Wearshoe	11.500inches $\pm$ 0.030	11.530 11.470		
11	Wearshoe	0.300inches $\pm$ 0.010	0.310 0.290		
12	Wearshoe	0.300inches $\pm$ 0.010	0.310 0.290		
13	Wearshoe	0.188inches + 0.005 - 0.001	0.193 0.187		
14	Wearshoe	0.375inches $\pm$ 0.010	0.385 0.365		
15	Wearshoe	0.063inches $\pm$ 0.010	0.073 0.053		

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